

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007601**Date Inspected:** 02-Jul-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Jia**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG Assembly Yard

2AE Segment

SMAW welding of weld joint 166 located on FB002-001.

Welder is identified as Mr. Bi Shijian (068764). ZPMC QC is identified as Mr. Li Jia.

The welding variables recorded by QC appeared to comply with WPS-B-P-2114-Tc-U4b-FCM-1.

2AW Segment

SMAW welding of weld joint 168 located on FB021-001.

Welder is identified as Mr. Jiang Zhen (068917). ZPMC QC is identified as Mr. Li Jia.

The welding variables recorded by QC appeared to comply with WPS-B-T-2114-Tc-U4b-FCM-1.

SMAW welding of weld joint 169 located on FB025-001.

Welder is identified as Mr. Gang Huaigang (037840). ZPMC QC is identified as Mr. Li Jia.

The welding variables recorded by QC appeared to comply with WPS-B-T-2114-Tc-U4b-FCM-1.

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### 1BE Segment

SMAW welding of weld joint 002 located on CA098.

Welder is identified as Mr. Zai Dawei (068097). ZPMC QC is identified as Mr. Li Jia.

The welding variables recorded by QC appeared to comply with WPS-B-T-2114-Tc-U4b-FCM-1 and Weld Report # B-WR5969.

### CB1

FCAW welding of weld joints 029 and 030 located on BP209-001.

Welder is identified as Mr. Cao Fei (220077). ZPMC QC is identified as Mr. Li Jia.

The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

FCAW welding of weld joints 017 and 018 located on BP211-001.

Welder is identified as Mr. Cao Fei (220077). ZPMC QC is identified as Mr. Li Jia.

The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

### 3BW Segment

QA Inspector observed back gouging of the weld seam SEG013A-015-007 located in between panel point 22 & 23.

QA Inspector was informed by ZPMC QC that ZPMC Ultra Sonic (UT) Technician found nonconforming discontinuities in various location of noted weld.

QA Inspector observed ZPMC UT Technician perform and accept UT inspection on the counter weights connection plates located at 3AW & 3BW. QA Inspector noted backing bar was present and is approximately 8mm to bolt hole edge. Bolt hole is measured to be at 24mm in diameter. Due to the size of bolts being installed at this location, clearance is limited for installation of bolt assembly. QA Inspector issued an incident report on this date for the welding observed.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (134-8257-0045), who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Alaniz,Joe	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer

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